

Date: Monday, 24/11/2008 10:18:21 AM
 User: Melanie Fauteux

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARPAD
Job Number : 43706	
Estimate Number : 10700	
P.O. Number :	Part Number : D34291
This Issue : 24/11/2008 S.O. No. :	Drawing Number : D3429 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : PURCHASED PARTS	Drawing Revision : A
Previous Run : 42779	Material :
Written By :	Due Date : 05/12/2008 Qty: 10 Um: Each
Checked & Approved By : <u>ME 08-11-24</u>	
Comment : Est: A 05.10.04 New Issue KJ/EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010S16GA	1010/1025 sheet 16GA
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Comment: Qty.: 0.1512 sf(s)/Unit Total: 1.5120 sf(s)
 1010/1025/A21/6aA steel sheet 0.063" thick
 Batch: 10S706 IB 8-12-1

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3429
 Dwg Rev: A
 Prog Rev: A

IB 8-12-1

(13)

2-Deburr if necessary

IB 8-12-1

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

IB 8-12-1

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

05.12.01

(13)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

Deburr if necessary

Form on Brake as per Dwg D3429 using Jigs DT8261 and DT8326. Identify as D3429-1
 Form Joggle as per Dwg D3429 on brake using Jig DT8158

IB 08/12/15

(13)

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

S 08/12/15 (X13)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description

Batch

A/R7560Hardcoat

M109560

Weld hardcoat as per Dwg D3429

EL 8-12-16 X13

8.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 08/12/16 (X13)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/12/16 (X13)

10.0

POWDER COATING

POWDER COATING



M109648



(13X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

1:20

OVEN TEMPERATURE:

320 8 F

FINISH TIME:

1:30

M-L 08/12/18

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

EL 08/12/18 (13)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

F P - 17

M-L 08/12/18

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Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/12/22 JF

Job Completion



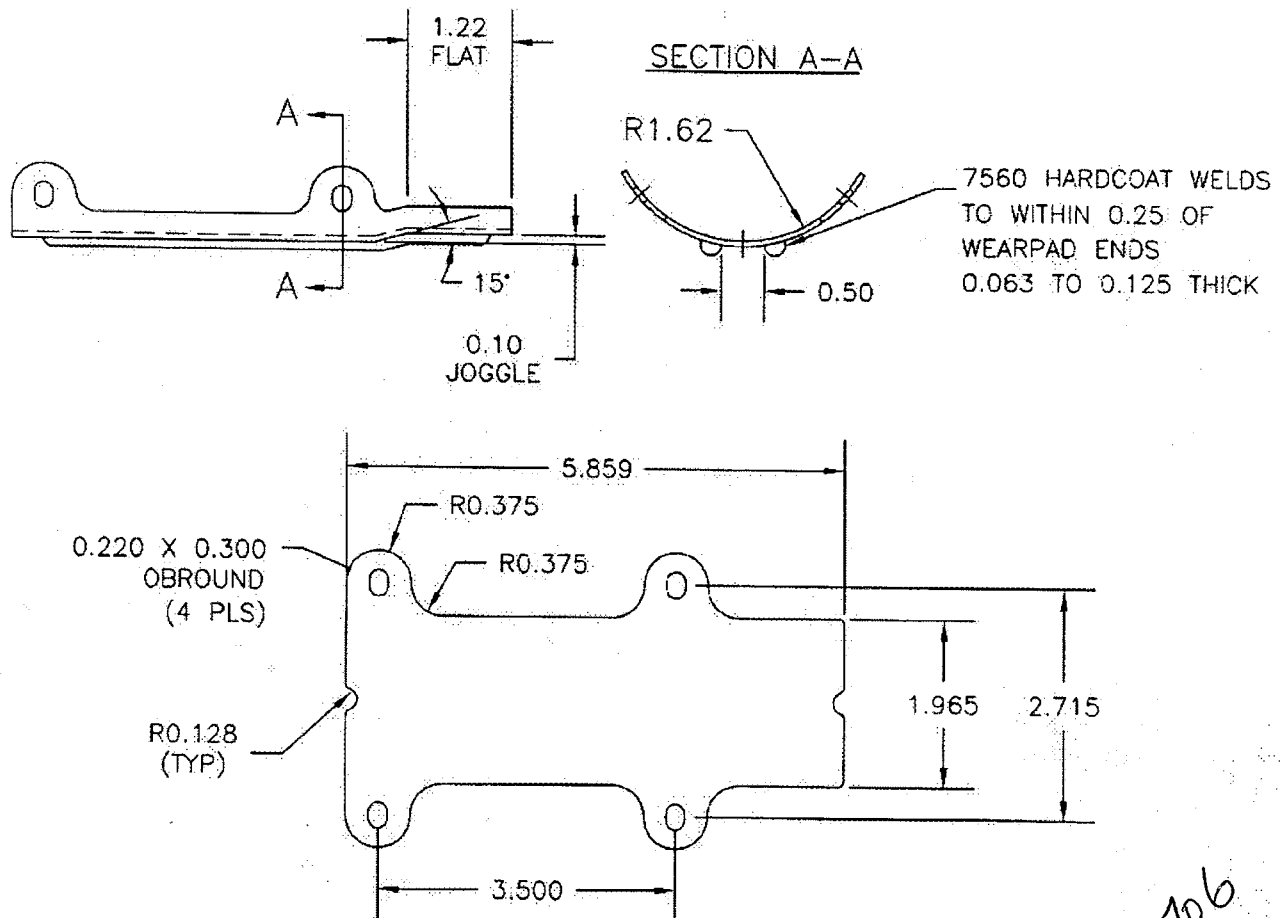
MF 08-12-18

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3429	REV. A SHEET 1 OF 1
DATE 05.04.18	TITLE WEARPAD		SCALE 1:2
A	05.04.18	NEW ISSUE	

RELEASED
05.09.06

REFERENCE ONLY

**D3429-1 WEARPAD**

- 1) BREAK ALL SHARP CORNERS 0.063 MAX
- 2) MATERIAL: 16 GAUGE AISI 1010-1025 OR ASTM A36/A366 STEEL (0.063 THICK)
- 3) FINISH: POWDER COAT GREY (REF. 4.3.5.5) PER DART QSI 005
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) WELD PER DART QSI 004

Wb43706

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